



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB6796941-201-3

RB67

Job Sh



11720
189230

Part No: RB6796941-201-3

Job Qty: 8 pcs

Part Name: Plug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/22/19

Job Tracking No:

Due Date: 2/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB6796941-201 Rev2 IPP Rev A 17.12.05 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	SL-154 - 1	8 pcs	2/1/19	2/1/19	0.00	2.67	SL-154 - 1		
120	QC 2	8 pcs	2/1/19	2/1/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S151794



Part: RB6796941-201-3

Job No: 189230

Serial No/Batch: S151794

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 02/07/19

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AMP 2019-07-07

130	QC 8	8 pcs	2/1/19	0.00 0.00	QC 8 - 12		
					QC 8 - 14		2/19/02/08
					QC 8 - 17		
					QC 8 - 20		
					QC 8 - 25		
					QC 8 - 3		
					QC 8 - 32		
					QC 8 - 33		
					QC 8 - 35		
					QC 8 - 38		
					QC 8 - 39		
					QC 8 - 4		
					QC 8 - 44		
					QC 8 - 45		
					QC 8 - 49		
					QC 8 - 58		
					QC 8 - 8		
					QC 8 - 9		
					QC 8 - 68		
					QC 8 - 67		
					QC 8 - 1 (A)		
140	QC 5	8 pcs	2/1/19	0.00 0.00	QC 5 - 10		
					QC 5 - 12		
					QC 5 - 17		
					QC 5 - 18		
					QC 5 - 19		
					QC 5 - 22		
					QC 5 - 24		
					QC 5 - 3		
					QC 5 - 38		
					QC 5 - 42		
					QC 5 - 43		
					QC 5 - 49		
					QC 5 - 51		
					QC 5 - 58		
					QC 5 - 68		
					QC 5 - 9		
					QC 5 - 50		
					QC 5 - 30		
150	Outsource - 12 - Black Oxide	8 pcs	2/1/19		GRO002-VC	10	22(9-02)-11
151	Packaging 2-1 - Receive - B4B	8 pcs	2/1/19	0.00 0.00	Packaging 2 - 1 - B4B		
					Packaging 2 - 2 - B4B		
					Packaging 2 - 3 - B4B		
					Packaging 2 - 5 - B4B		
					Packaging 2 - 4 - B4B		
					Packaging 2 - 6 - B4B		
					Packaging 2 - 7 - B4B		
					Packaging 2 - 8 - B4B		
					Packaging 2 - 9 - B4B		
					Packaging 2 - 10 - B4B		
					Packaging 2 - 11 - B4B		
					Packaging 2 - 12 - B4B		
					Packaging 2 - 13 - B4B		
					Packaging 2 - 14 - B4B		
					Packaging 2 - 15 - B4B		
					Packaging 2 - 16 - B4B		
					Packaging 2 - 17 - B4B		
					Packaging 2 - 18 - B4B		
					Packaging 2 - 19 - B4B		

				Packaging 2 - 20 - B4B		
				Packaging 2 - 21 - B4B		
				Packaging 2 - 22 - B4B		
				Packaging 2 - 23 - B4B		
				Packaging 2 - 24 - B4B		
				Packaging 2 - 25 - B4B		
				Packaging 2 - 26 - B4B		
				Packaging 2 - 27 - B4B		
				Packaging 2 - 28 - B4B		
				Packaging 2 - 29 - B4B		
				Packaging 2 - 30 - B4B		
				Packaging 2 - 31 - B4B		
				Packaging 2 - 32 - B4B		
				Packaging 2 - 33 - B4B		
				Packaging 2 - 34 - B4B		
				Packaging 2 - 35 - B4B		
				Packaging 2 - 36 - B4B		
152	QC 6	8 pcs	2/1/19	0.00 0.00	QC 6 - 38	
					QC 6 - 42	
					QC 6 - 9	
					QC 6 - 68	MAR 0 1 2019 68
					QC 6 - 61	9-89
153	Packaging 3-1 - Stock - B4B	8 pcs	2/1/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190	QC 21 - SA	8 pcs	2/1/19	0.00 0.00	QC 21 - SA - 21	

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Part Op **110** - SL-154 (MORI SL-154 LATHE) 1-Machine as per folio FB 701 FOLIO REV: AA DWG REV: 2
 Descriptions: 2-Deburr

120 - QC2 Machining-4 (QC2- Inspect parts off machine FAI/FAIB)

130 - QC8 Machining-4 (QC8- Inspect parts - second check)

140 - QC5 (QC5- Inspect part completeness to step on W/O)

150 - Outsource12 (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

151 - Packaging2 (Receive & Inspect for Damage & Mat'l Certs)

152 - QC6 (QC6- All purchased or subcontracted products)

153 - Packaging3-2 (Identify as per dwg & Stock Location: _____)

190 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-1144-R0.625	AISI 1144 Stressproof Round Bar 0.625"	1.2800 ft (.16 ea)	110-SL-154 - 1	<u>5000 803</u> <u>20"</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-SL-154 - 1	MT-1144-R0.625	1	6	0

Part Specifications

Specifications could not be found.



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RB6796941-201-3
Job Sheet 189230



Part No: RB6796941-201-3

Job Qty: 8 ea

Part Name: Plug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/22/19

Job Tracking No:

Due Date: 2/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB6796941-201 Rev2 IPP Rev A 17.12.05 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	2/1/19	2/1/19	0.00	0.00	Start Up Machining-3		
110	Mori Seiki	8 pcs	2/1/19	2/1/19	0.00	2.67	SL-154		
120	QC	8 pcs	2/1/19	2/1/19	0.00	0.00	QC2 Machining-4		
130	QC	8 pcs	2/1/19	2/1/19	0.00	0.00	QC8 Machining-4		
140	QC	8 pcs	2/1/19	2/1/19	0.00	0.00	QC5		
150	Outsource	8 pcs	2/1/19	2/1/19			GRO002-VC	10	
151	Packaging	8 pcs	2/1/19	2/1/19	0.00	0.00	Packaging2		
152	QC	8 pcs	2/1/19	2/1/19	0.00	0.00	QC6		
153	Packaging	8 pcs	2/1/19	2/1/19	0.00	0.00	Packaging3-2		
190	QC21-SA	8 Ea	2/1/19	2/1/19	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per folio FB 701 FOLIO REV: _____ DWG REV: _____ 2-Deburr
Descriptions: 150 - -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of
Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-1144-R0.625	AISI 1144 Stressproof Round Bar 0.625"	1.2800 ft (.16 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-1144-R0.625	1	6	0

Part Specifications

Specifications could not be found.

Plex 1/22/19 7:34 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

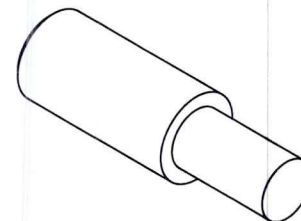
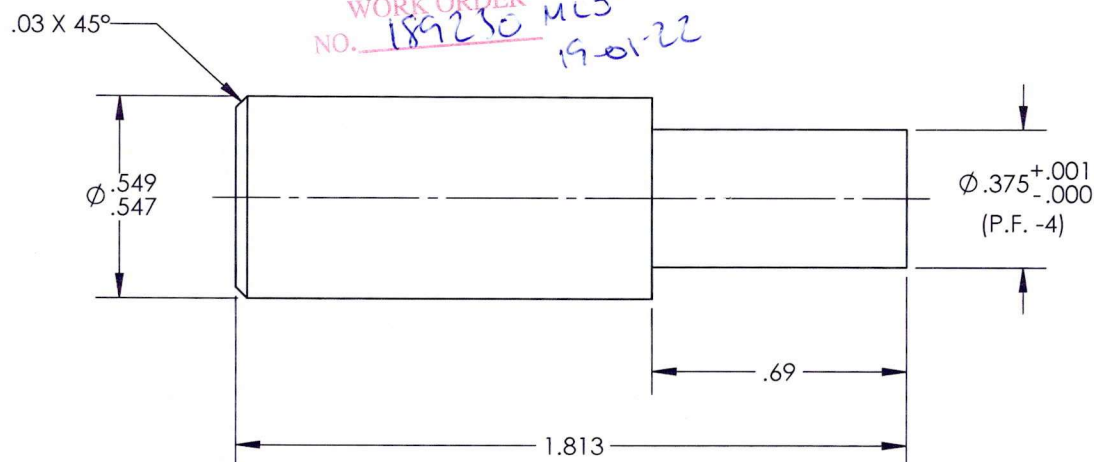
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
2	17-0082	-3 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D.			4/7/2017	RJC JAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189230 ML5
19-01-22



③

PLUG

DART AEROSPACE	
TITLE STARTER PULLER ASSY.	
DWG NO. RB6796941-201-3	REV 2
MAT'L STRESSPROOF	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125/✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 04/07/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 04/10/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 04/10/2017	USED ON MODEL
APPROVED: JAG 04/13/2017	SEE NOTE 1, SHEET 1
SCALE 2:1	DATE 7/17/2000 SHEET 2 OF 3



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
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Tel (613) 632-5200

PURCHASE ORDER

PO042564



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042564

PO Date: 2/11/19

Due Date: 2/15/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments: ** Please confirm if Feb. 15 ok to receive these back **

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189872	RBBP1425-103-03	Keeper (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	2/15/19	28 pcs	0 pcs	28 pcs	\$3.89/pcs	\$108.92
2	184322	RBEM652V3002101-M-45	Stud Extension -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	2/15/19	6 pcs	0 pcs	6 pcs	\$3.35/pcs	\$20.10



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PURCHASE ORDER PO042564



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	181976	RB T103217-101-1	Body -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	2/15/19	7 Ea	0 Ea	7 Ea	\$6.20/Ea	\$43.40
				x7		FEB 20 2019		DP			
4	188961	RBBP1425-105-03	Keeper (Outside Processing) - Black Oxide) -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	2/15/19	28 pcs	0 pcs	28 pcs	\$2.89/pcs	\$80.92
				L7B		FEB 20 2019		DP			
5	189449	RBT18524-3	Puller -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Steel -Certificate of Conformity is required	Firmed	-	2/15/19	10 pcs	0 pcs	10 pcs	\$2.80/pcs	\$28.00
				x10		FEB 20 2019		DP			



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PURCHASE ORDER PO042564



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	189230	RB6796941-201-3	Plug Outsource12 (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	2/15/19	8 pcs	0 pcs	8 pcs	\$2.12/pcs	\$16.96

FEB 20 2019

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Grand Total: \$298.30

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 2/12/19 9:17 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(016767-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

016767 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courrier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
18-Feb-2019		Aman		042564				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBBP1425-103-03 Rev.	RBBP1425-103-03 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS1	OXIDE-BLACK CH	28	28	0	0	0
2	RBEM652V3002101-M-45 Rev.	RBEM652V3002101-M-45 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-PRF-16173 GRADE3 CLASS 1 WIPE OF EXCESS OIL	OXIDE-BLACK CH	6	6	0	0	0
3	RBT103217-101-1 Rev.	RBT103217-101-1 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	7	7	0	0	0
4	RBBP1425-105-03 Rev.	RBBP1425-105-03 01-OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	28	28	0	0	0
5	RBT18524-3 Rev.	RBT18524-3 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL MIL-PRF-16173 GRADE3 CLASS 1 WIPE OF EXCESS OIL	OXIDE-BLACK CH	10	10	0	0	0
6	RB6796941-201-3 Rev.	PLUG BLACK OXIDE MIL-C-13924C CLASS 1	BLACK-OXIDE CH	8	8	0	0	0

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.